

Work Order ID 139618

Monday, November 30, 2015 11:08:51 AM

139618

Please cut
Jan 18-20

Page 1

Item ID: D2583 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Latch Bracket
Start Date: 11/30/2015 Start Qty: 15.00 ***15*** 24
Required Date: 11/30/2015 Req'd Qty: 15.00 ***15*** 24 SU
Reference: Cust Item ID:
Customer:

Approvals: Process Plan: MLJ Date: DEC 03 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2583	Rev B

100 FLOW WATER JET 0.00
100
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D2583 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary
(27) 12/16/15

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.00
Quality Control
(27) 12/16/15

120 QC8- Inspect parts - second check 0.00
120
QC Memo 0.00
Quality Control
(27) 12/16/15

DAS
38
9-89

JAN 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐
Design ☐	☐	Operator ☐		☐	Set-up ☐	☐	Folio/Program ☐
Doc/Data ☐	☐	Offset/Setup ☐		☐	BOM/Route ☐	☐	Grain ☐
Equip/Tooling ☐	☐	Supplier ☐		☐	Cracks ☐	☐	Weld ☐
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Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter ☐	☐	Misaligned/off center ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
Misidentified ☐	☐	Past Due ☐					

Work Order ID 139618

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139618

Page 3

Item ID: D2583 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Latch Bracket
 Start Date: 11/30/2015 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 11/30/2015 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum	0.00							
160	<i>M.132729</i>					<i>27</i>	<i>16-01-25</i>	<i>233</i>	
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>3:15</i> OVEN TEMPERATURE: <i>345</i>								
	FINISH TIME: <i>3:45</i>								
170	QC3- Inspect Part Finish	0.00							
170									DAS 38 9-88
QC	Memo	0.00				<i>(27)</i>			
Quality Control									JAN 26 2016
180	Identify as per dwg & Stock Location: <i>SH1</i>	0.00							
180						<i>27</i>			<i>233</i>
Packaging	Memo	0.00							<i>03</i>
Packaging						JAN 26 2016			<i>00</i>

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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		OTHER : ☐							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.02							
Quality Control									

MCS JAN 26 2016

MCS JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, November 30, 2015 11:08:51 AM

Page 1

Work Order ID: 139618

139618

Parent Item: D2583

D2583

Parent Item Name: Latch Bracket

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased			No	100	sf	66.6984	0.1169	1.84579			

M5052H32S 040

5052-H32 .040 Sheet

Dec 16 / 07 / 19

Location

Loc Qty

Loc Code

MAT023

66.6984

m129530

4.0984

m132546

17.6

m132886

5

m133550

40

5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

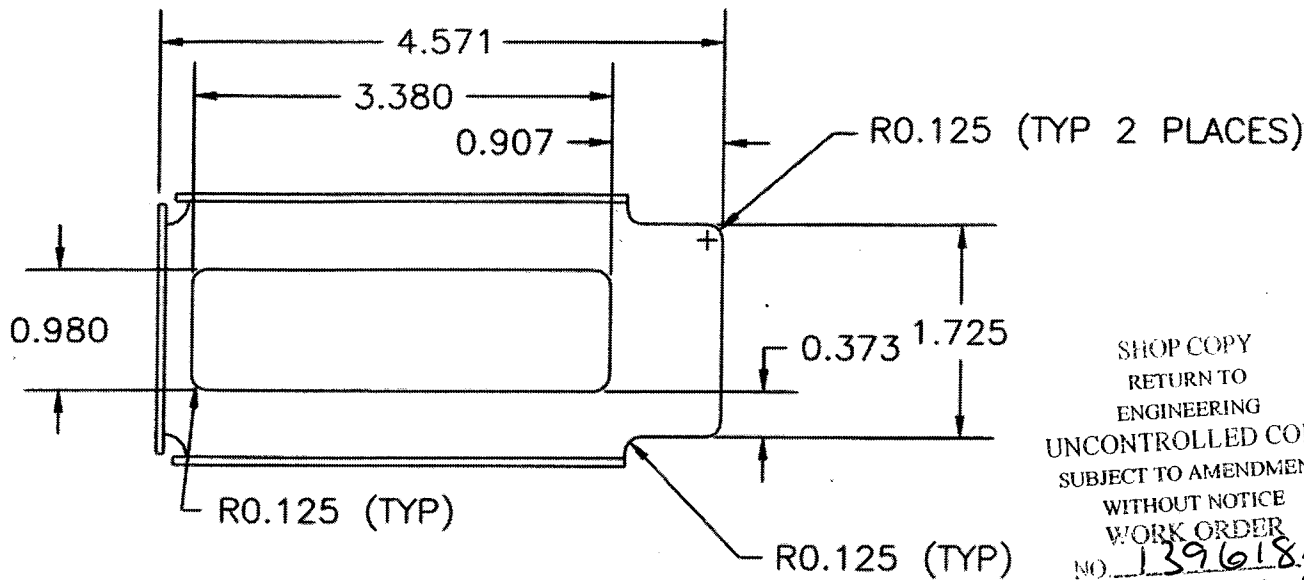
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LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
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				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

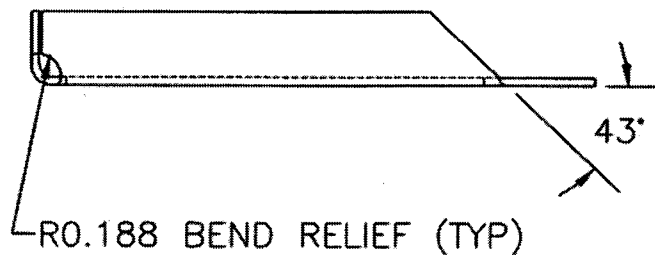
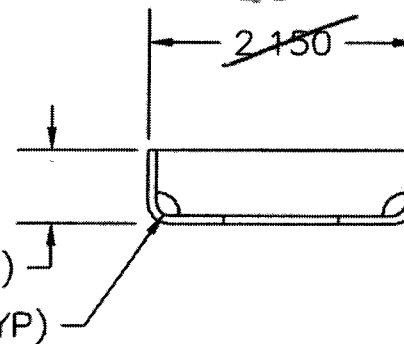


RELEASED
DATE 99.02.25
KE

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B SHEET 1 OF 1
A	96.07.10	NEW ISSUE		SCALE 2:3
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139618 MJS
15-12-03 KE
220
99.02.26



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED